

SWING & PIN EXPANDINGTYPE

UBL & Multi-jaw Combination Chucks

We offer a wide selection of new UBL & MUL Chucks for thin-walled work-pieces.



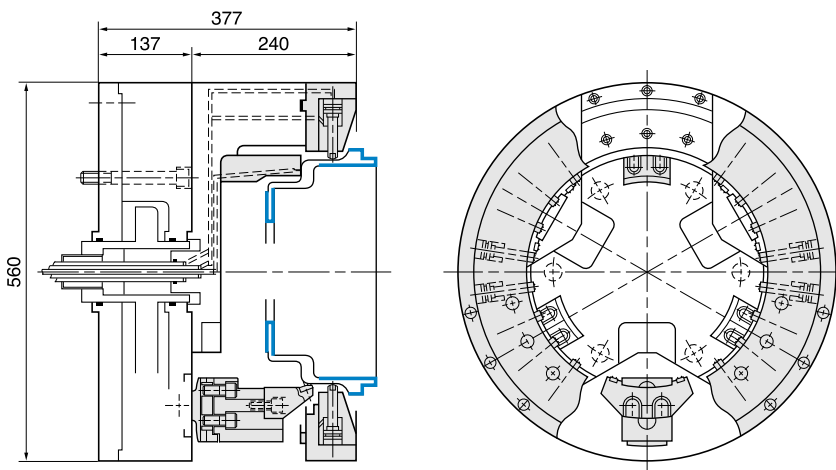
This new design chuck combines a UBL Chuck (Universal Ball-Lok for cast and forged work-pieces / Original developed by N.A. Woodworth <U.S.A.>) and the MUL Chuck (Multi-jaw Chuck for the thin-walled work-pieces / Developed by SOUL, Japan). It is capable of finishing truck brake drums in only one chucking step. The MUL clamp pins and cap-type auxiliary clamp pins enable to clamp O.D. of wide variety of brake drums of vehicles in size from large to small powerfully yet softly.

Flexible correspondence by our SPECIAL DESIGN.

The UBL & MUL Combination Chuck is ideally suited not only to brake drums but also to streamlining the production of various other thin-walled work-pieces. Moreover, our total design approach to the MUL chuck gives the combination chuck the versatility to meet a variety of needs that vary with the shape and number of thin-walled work-pieces, the machining conditions, and the required accuracy.

- 1** Provides powerful chucking.
- 2** Offers the highest level of roundness for O.D. clamping.
- 3** Allows all turning operations to be completed on one machine.
- 4** Incorporates user-friendly design.
- 5** MUL guide ensures operation safety.
- 6** Eliminates the effects of chattering.
- 7** The long-stroke MUL suitable for a variety of work-pieces.

Dimension diagram



Specification of practical examples

	UBL side	MUL side
Body unit dimension	φ 560 x 137	φ 560 x 240
Actuator stroke	25 mm	—
Operate by	30 kN (Max. Draw bar pressure)	3.5 MPa (Max. Oil pressure)
Jaw travel (Dimension)	30 mm	44 mm
Clamping force (MAX)	36 kN	1.4 kN x 24 (33kN)
Rough operation	adaptation	adaptation
Finish operation	—	adaptation
Others	Q'ty of work-piece : 13 kinds Cutting condition : No report from customer Requirement accuracy : Roundness 30 μ (Test result : under 10 μ)	

Due to correspond to the customer's rationalize request that would like to operate by vertical CNC lathe turning for small truck brake drum, we had offered our UBL & Multi-jaw combination chuck to operate efficiently by 1 chuck for rough hard turning / finish turning. This chuck could also perform efficiently for finish operation of brake face which portion is necessary to be finished with high roundness accuracy.